

Work Order ID 48651

Page 1

July 1, 2009 8:56:34 AM

Item ID: D3851-1KGY

Accept



Setup Start



Revision ID: B

Stop



Item Name: Doubler-Grey

Start Date: 07/15/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 08/03/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: BProg Rev: B

2-Deburr if necessary

RB 9-7-1
Ep09/07/02 @ (10)

RB 9-7-1

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Work Order ID 48651



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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

=> 80516762 (410)

130

Identify as per dwg & Stock Location: 138A

0.00



Packaging

Memo

0.00

Packaging

P 8/2/2 (10)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09607107 HA

MF 09-07-07

Picklist Print

July 1, 2009 8:56:33 AM

Work Order ID: 48651



Parent Item: D3851-1KGYRevB



Parent Item Name: Doubler-Grey

Start Date: 07/15/2009

Required Date: 08/03/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ MKYD6185S.080-P3- 52068		Purchased	No			100	sf	937.4732	0.1000			



Kydex steel grey

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

111807

937.47

937.47

111807

WB 9-7-1

Date: Thursday, 18/06/2009 10:05:25 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOUBLER, GREY
Job Number : 48651	
Estimate Number : 13974	
P.O. Number :	Part Number : D38511KGY
This Issue : 18/06/2009 S.O. No. :	Drawing Number : D3851 REV B
Prsht Rev. : NC	Project Number :
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run :	Material : MKYD6185S080P352068
Written By : _____	Due Date : 25/06/2009 Qty: 1 Um: Each
Checked & Approved By : _____	
Comment : Est. Rev A New Issue 09/06/02 DL	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MKYD6185S080P352068	6185 Kydex .080 steel grey
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Comment: Qty.: 0.1050 sf(s)/Unit Total: 0.1050 sf(s)

6185 KYDEX .080" Grey

batch: 111801 HB 9-7-1

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3851

Dwg Rev: B

Prog Rev: B

HB 9-7-1

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



HB 9-7-1

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

Sort 2/22 09/07/02 @

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Date: Thursday, 18/06/2009 10:05:26 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER, GREY

Job Number: 48651

Part Number: D38511KGY

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



DART AEROSPACE LTD	Work Order:	48651
Description: <i>DOUBLE</i>	Part Number:	D3851-1KGY
Inspection Dwg: D3851-1 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

x

Prototype

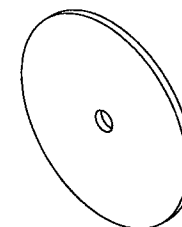
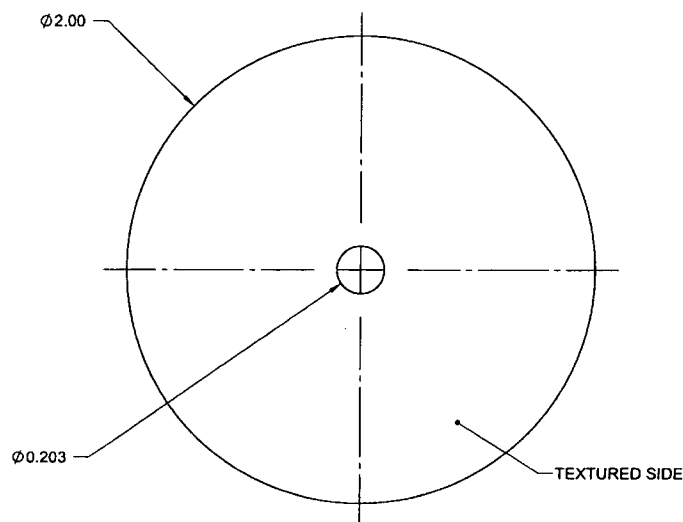
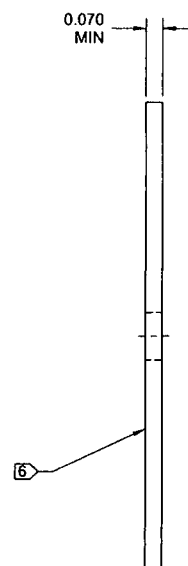
[illegible]

Measured by:	IB	Audited by:	S	Prototype Approval:	2/
Date:	9-7-1	Date:	09/6/02	Date:	4

Rev	Date	Change	Revised by	Approved
A	...	New Issue	KJ/JLM	

8 7 6 5 4 3 2 1

D
C
B
A





WLC 11/15/05

D3851-1 DOUBLER

RELEASED
09/05/22

- NOTES:**
- 1) MATERIAL: SEE TABLE
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
 - 7) WEIGHT: N/A

PART NUMBER	DESCRIPTION
 D3851-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
 D3851-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

B	ADD STEEL GRAY COLOUR OPTION, ADD IVORY P/N D3851-1KIV AND ADD STEEL GRAY P/N D3851-1KGY (ZN A5-1)	PH	09.05.05
A	NEW ISSUE	PH	08.11.03
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>RL</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>RL</i>		
CHECKED	<i>RL</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>RL</i>	D3851	SHEET 1 OF 1
APPROVED	<i>RL</i>	TITLE	SCALE
DE APPR.	<i>RL</i>	DOUBLER	NTS
DATE	09.05.05	COPYRIGHT © 2005 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

8 7 6 5 4 3 2 1